

# Work Order ID 73693

Tuesday, September 13, 2011 10:47:54 AM



Page 1

Item ID: D412-698-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Automatic Door Opener, LH/RH

Start Date: 9/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: [Signature] Date: 10/9/13

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-698	Rev E

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-023

CHG002

Silva

for ME 11-9-13

110 0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/9/13

120 0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Silva

+

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73693**

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Item Name: Automatic Door Opener, LH/RH

Start Date: 9/13/2011 Start Qty: 1.00



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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-698-023

Location: DPPP Rev: B

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

mf

11-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 13, 2011 10:48:00 AM

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Work Order ID: 73693

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 9/13/2011

Required Date: 9/27/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-07-12 JLM  
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD516L Washer	NAS1149D0516J	Purchased	No			120	Each	12.0000	2	2			
<div>Location</div> <div>ST347</div> <div>112466</div> <div>Loc Qty</div> <div>12</div> <div>12</div> <div>Loc Code</div>													
D3552-11 Door Prop		Manufactured	No			120	Each	17.0000	1	1			
<div>Location</div> <div>ST272</div> <div>68791</div> <div>72239</div> <div>Loc Qty</div> <div>17</div> <div>5</div> <div>12</div> <div>Loc Code</div>													
D3594-043 Floor Doubler Assembly, LH		Manufactured	No			120	Each	19.0000	1	1			
<div>Location</div> <div>ST234B</div> <div>67012</div> <div>71690</div> <div>Loc Qty</div> <div>19</div> <div>9</div> <div>10</div> <div>Loc Code</div>													
D3594-044 Floor Doubler Assembly, RH		Manufactured	No			120	Each	17.0000	1	1			
<div>Location</div> <div>ST234B</div> <div>68387</div> <div>71691</div> <div>Loc Qty</div> <div>17</div> <div>7</div> <div>10</div> <div>Loc Code</div>													

11/14/11

1

1

11/14/11

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 73693

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 9/13/2011

Required Date: 9/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3594-5 Manufactured No

120 Each

19.0000

1



Door Doubler

Location

Loc Qty

Loc Code

ST234A

19

66651

1

71692

18

D3622-1 Manufactured No

120 Each

43.0000

2



Ball Stud

Location

Loc Qty

Loc Code

ST070

43

71540

13

72102

30

MS20426AD4-4 Purchased No

120 Each

2,011.000

2



Rivet

Location

Loc Qty

Loc Code

ST317

2011

116188

2011

MS21073L5 Purchased No

120 Each

90.0000

1



nut plate

Location

Loc Qty

Loc Code

ST302

90

117395

90

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X	-	D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW